Date: Monday, 25/08/2008 9:56:05 AM
User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: 350 SADDLE
Job Number	: 41613		
Estimate Number	: 12451		
P.O. Number	:	**Part Number**	: D35001
This Issue	: 25/08/2008 **S.O. No.** :	**Drawing Number**	: D3500 REV C
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: / / **Type** : MACHINED PARTS	**Drawing Revision**	: C
Previous Run	: 41602	**Material**	:
Written By	:	**Due Date**	: 30/09/2008 **Qty:** 16 **Um:** Each
Checked & Approved By	: JLD 08.8.25		
Comment	: Est Rev:A New Issue 06-06-15 JLM		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	D6102013	Saddle Billet

Comment: Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s)
6061-T6 7.0x6.5x2.0
350 Saddle Billet
Batch: B41962

SA 08/10/19 (16)

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1

Comment: HAAS CNC VERTICAL MACHINING #1
Program Batch No. SA Double check by: JL

1-Machine Step No 1 per Folio FA641 and inspect per attached Dimension Sheets
2-Machine Step No 2 per Folio FA641and inspect per attached Dimension Sheets
3-Machine Step No 3 per Folio FA641 and inspect per attached Dimension Sheets
4-Deburr
5-Tumble to remove sharp edges.

SA 08/10/19 (16)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 08/10/20 (16)

4.0	QC8	SECOND CHECK

Comment: SECOND CHECK

SA 08/10/21 (16)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Date: Monday, 25/08/2008 9:56:05 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** 350 SADDLE

Job Number: 41613 **Part Number:** D35001

Job Number:

Seq. #:	Machine Or Operation:	Description :
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1
Acid etch and Alodine as per QSI 005 4.1 08-10-23 x16

6.0	POWDER COATING	POWDER COATING

M109152

Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 10:15am
OVEN TEMPERATURE: 320°F
FINISH TIME: 10:45am 08-10-23 x16

7.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION

Comment: INSPECT POWDER COAT

8.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and Stock
Location:_____

9.0	QC21	FINAL INSPECTION/W/O RELEASE

08/10/24

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

JMF 08-10-24

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	41613
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500	**Rev:** C		Page 1 of 1

				Recorded Actual Dimensions					
Dim	**Min**	**Max**	**Go/No Go Gauge**	**1**	**2**	**3**	**4**	**By**	**Date**
A	0.483	0.490		.486	.486	.486	.486		
B	1.175	1.185		1.178	1.178	1.178	1.178		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.178	1.178	1.178	1.178		
E	0.365	0.385		.373	.373	.373	.373		
F	0.490	0.510		.499	.499	.499	.499		
H	R.470	R.530		.500	.500	.500	.500		
I	R1.575	R1.595		1.585	1.585	1.585	1.585		
J	0.240	0.260		.250	.250	.250	.250		
K	0.490	0.510		.500	.500	.500	.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.320		.320	.320	.320	.320		
N	0.256	0.262		.258	.258	.258	.258		
O	6.500	6.520		6.500	6.500	6.500	6.500		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.820	2.820	2.820	2.820		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.554	.554	.554	.554		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.112	.112	.112	.112		
AA	R1.125	R1.145		1.130	1.130	1.130	1.130		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.625	.625	.625	.625		
AD	0.240	0.260		.260	.260	.260	.260		
AE	1.810	1.830		1.820	1.820	1.820	1.820		
AF	0.240	0.260		.250	.250	.250	.250		
AG	0.140	0.160		.152	.152	.152	.152		
AH	0.140	0.160		.160	.160	.160	.160		
AI	0.140	0.160		.150	.150	.150	.150		
Accept/Reject									

Measured by:	SP
Date:	08/10/19

Audited by	MK
Date:	08/10/21

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	EC/KJ	

DART AEROSPACE LTD		Work Order:	41613
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500	Rev: C		Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	~~4~~ 5	~~2~~ 6	~~3~~ 7	~~4~~ 8	By	Date
A	0.483	0.490		.485	.485	.485	.485		
B	1.175	1.185		1.178	1.178	1.178	1.178		
C	3.145	3.155		3.150	3.1500	3.1500	3.150		
D	1.175	1.185		1.178	1.178	1.178	1.178		
E	0.365	0.385		.373	.373	.373	.373		
F	0.490	0.510		.500	.500	.500	.500		
H	R.470	R.530		.500	.500	.500	.500		
I	R1.575	R1.595		1.585	1.585	1.585	1.585		
J	0.240	0.260		.250	.250	.250	.250		
K	0.490	0.510		.500	.500	.500	.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.320		.320	.320	.320	.320		
N	0.256	0.262		.258	.258	.258	.258		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.820	2.820	2.820	2.820		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.550	.550	.550	.550		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.112	.112	.112	.112		
AA	R1.125	R1.145		1.135	1.135	1.135	1.135		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.625	.625	.625	.625		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.810	1.830		1.820	1.820	1.820	1.820		
AF	0.240	0.260		.260	.260	.260	.260		
AG	0.140	0.160		.150	.150	.150	.150		
AH	0.140	0.160		.160	.160	.160	.160		
AI	0.140	0.160		.150	.150	.150	.150		
Accept/Reject									

Measured by:	
Date:	08/10/20

Audited by	
Date:	08/10/21

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	EC/KJ	

DART AEROSPACE LTD		Work Order:	41613
Description: Saddle		Part Number:	D3500-1
Inspection Dwg: D3500	**Rev:** C		Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	9 1	10 2	11 3	12 4	By	Date
A	0.483	0.490		.484	.484	.485	.485		
B	1.175	1.185		1.178	1.178	1.178	1.178		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.178	1.178	1.178	1.178		
E	0.365	0.385		.373	.373	.373	.373		
F	0.490	0.510		.500	.500	.500	.500		
H	R.470	R.530		.500	.500	.500	.500		
I	R1.575	R1.595		1.585	1.585	1.585	1.585		
J	0.240	0.260		.250	.250	.250	.250		
K	0.490	0.510		.500	.500	.500	.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.320		.320	.320	.320	.320		
N	0.256	0.262		.258	.258	.258	.258		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.820	2.830	2.820	2.820		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.550	.550	.550	.550		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.112	.112	.112	.112		
AA	R1.125	R1.145		1.135	1.135	1.135	1.135		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.624	.624	.624	.624		
AD	0.240	0.260		.250	.260	.260	.260		
AE	1.810	1.830		1.820	1.820	1.820	1.820		
AF	0.240	0.260		.250	.250	.260	.260		
AG	0.140	0.160		.150	.150	.150	.150		
AH	0.140	0.160		.160	.160	.160	.160		
AI	0.140	0.160		.150	.150	.150	.150		
Accept/Reject									

Measured by:	
Date:	08/10/21

Audited by	
Date:	08/10/21

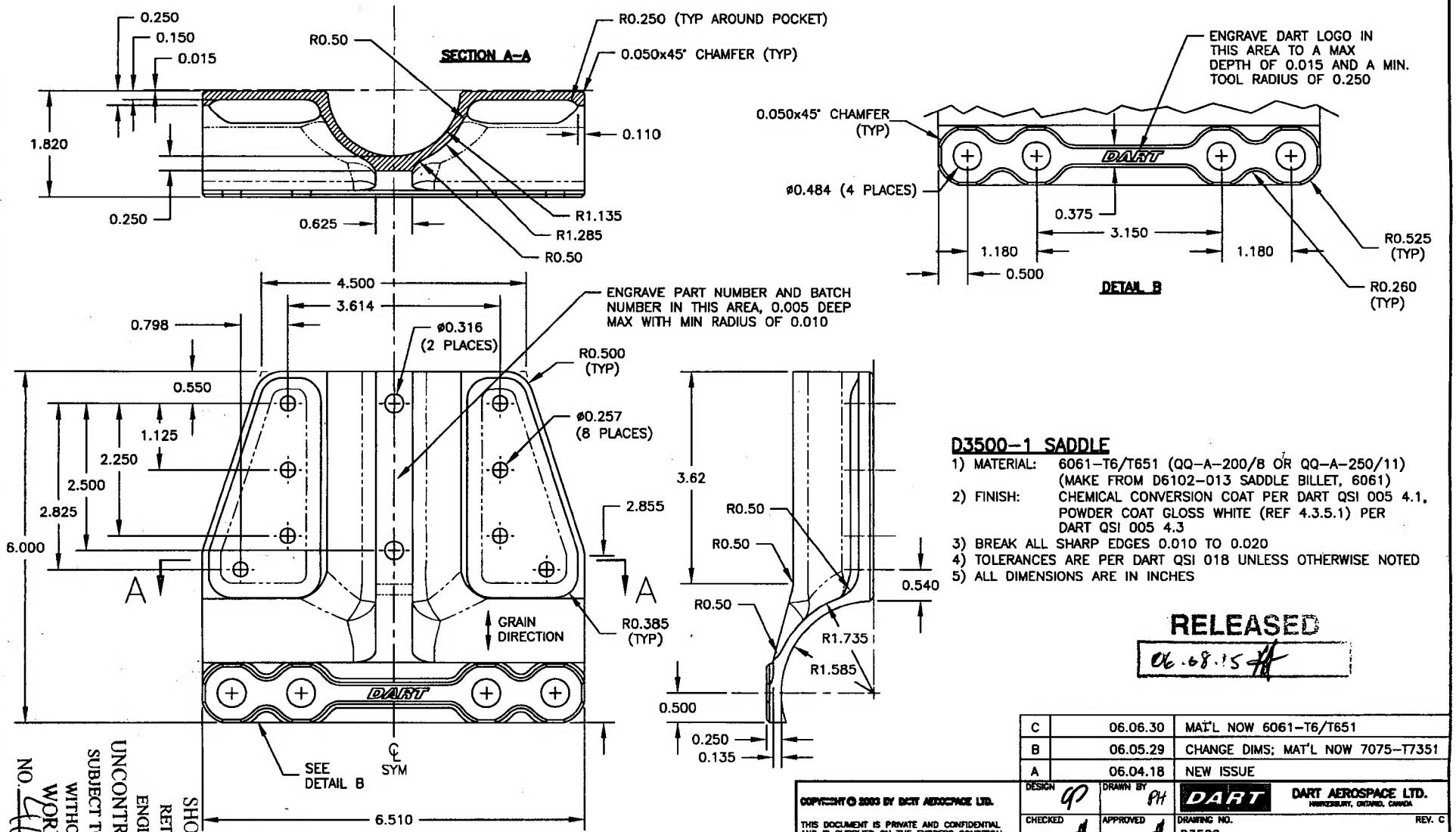
Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	EC/KJ	

DART AEROSPACE LTD	Work Order:	41613
Description: Saddle	Part Number:	D3500-1
Inspection Dwg: D3500 **Rev:** C		Page 1 of 1

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1 13	2 14	3 15	4 16	By	Date
A	0.483	0.490		.485	.485	.485	.485		
B	1.175	1.185		1.178	1.178	1.178	1.178		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.178	1.178	1.178	1.178		
E	0.365	0.385		.373	.373	.373	.373		
F	0.490	0.510		.500	.500	.500	.500		
H	R.470	R.530		.500	.500	.500	.500		
I	R1.575	R1.595		1.585	1.585	1.585	1.585		
J	0.240	0.260		.250	.250	.250	.250		
K	0.490	0.510		.500	.500	.500	.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.320		.320	.320	.320	.320		
N	0.256	0.262		.258	.258	.258	.258		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.820	2.820	2.820	2.820		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.550	.550	.550	.550		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	.050	.050	.050		
Y	0.100	0.120		.110	.110	.110	.110		
AA	R1.125	R1.145		1.135	1.135	1.135	1.135		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.625	.625	.625	.625		
AD	0.240	0.260		.260	.260	.260	.260		
AE	1.810	1.830		1.820	1.820	1.820	1.820		
AF	0.240	0.260		.250	.250	.250	.250		
AG	0.140	0.160		.150	.150	.150	.150		
AH	0.140	0.160		.160	.160	.160	.160		
AI	0.140	0.160		.150	.150	.150	.150		
Accept/Reject									

Measured by:		Audited by	
Date:	08/10/20	Date:	08/10/21

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	EC/KJ	



D3500-1 SADDLE

1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/11) (MAKE FROM D6102-013 SADDLE BILLET, 6061)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1, POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
3) BREAK ALL SHARP EDGES 0.010 TO 0.020
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES

RELEASED
06.08.15

C	06.06.30	MAT'L NOW 6061-T6/T651
B	06.05.29	CHANGE DIMS; MAT'L NOW 7075-T7351
A	06.04.18	NEW ISSUE

DESIGN: GP	DRAWN BY: PH	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	
CHECKED:	APPROVED:	DRAWING NO. D3500	REV. C
DATE: 06.06.30		TITLE: SADDLE	SCALE: 2:3
			SHEET 1 OF 1

SHOP COPY
RETURN TO ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT WITHOUT NOTICE
WORK ORDER NO. 41612